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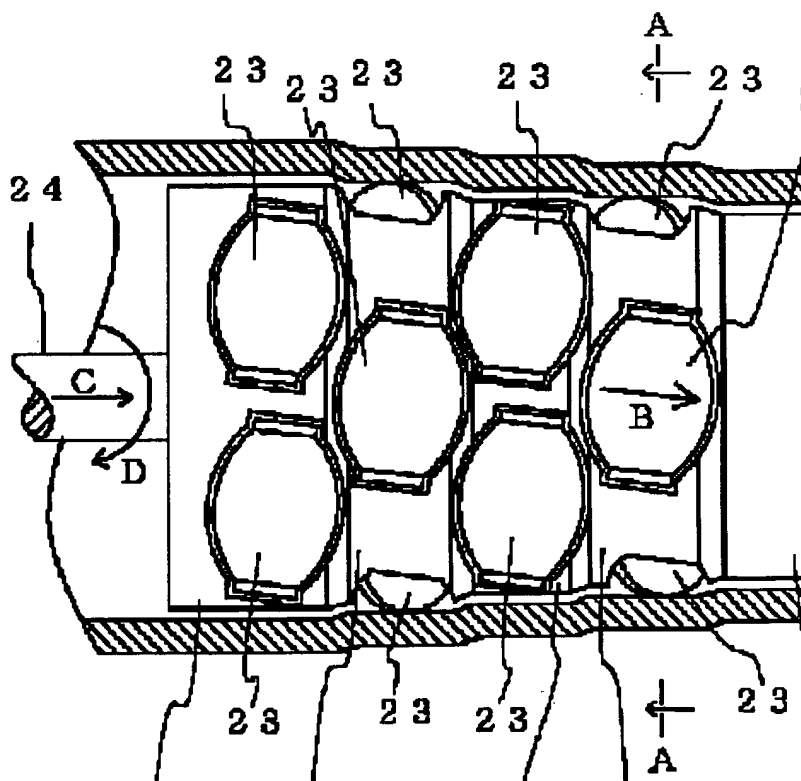
**(54) EXPANSION  
MANDREL, AND METHOD  
FOR EXPANDING LONG  
TUBE USING THE  
MANDREL**

(57) Abstract:

**PROBLEM TO BE SOLVED:** To provide an expanding method of a long tube in which the friction resistance is small, the energy efficiency is high, and the dimensional accuracy is excellent in expanding the long steel tube.

**SOLUTION:** An expansion mandrel 20 is passed from one opening end of a long steel tube 26, a plurality of mandrel rollers 23, 23... provided on an outer circumferential surface of an expansion mandrel body 25 are pressed against an inner wall surface of the long tube 26 so as to be expanded outwardly in the radial direction while the expansion mandrel 20 is rotated in an advancing manner.

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